



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

650.6213

Job Sheet 210873



Part No: 650.6213

Job Qty: 5 pcs

Part Name: Banjo -10



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/24/20

Job Tracking No:

Due Date: 7/9/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: 650.6200 REV.PE1 IPP REV:A 20.06.10 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	5 pcs	7/2/20		1.00	1.25	Doosan - 1		JB 20.07.21
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		
110	QC 2	5 pcs	7/2/20		0.00	0.00	QC 2 - 1		JB 20.07.21
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S289246



Part: 650.6213

Job No: 210873

Serial No/Batch: S289246

Revision: REV.PE1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/21/20

Plex 6/24/20 3:54 PM Dart.Renwick.Jennifer

DAS
62
9-89DAS
62
9-89

AMIR P. JAWA

10221 YHMHMLZPH

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	5 pcs	7/2/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
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					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Outsource - 17 - Passivate	5 pcs	7/9/20		GRO002-VC 5
140	Packaging 2-1 - Receive - B4B	5 pcs	7/9/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
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					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 37 - B4B	
150 QC 6	5 pcs	7/9/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				QC 6 - 82	
160 Packaging 3-1 - Stock - B4B	5 pcs	7/9/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	5 pcs	7/9/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

FD325

Part Op 100 - 1-Machine as per folio F FOLIO REV: AA DWG REV: PEI 2-Debur

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - -Issue P/O; 46796 PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel - Certificate of Conformity is required

140 - Certificate of Conformity is required

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	.9100 ft (.182 ea)	100-SL-154 - 1	5285031

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M17-4-H1150-R1.500	1	0	0
Part Specifications				
Specifications could not be found.				

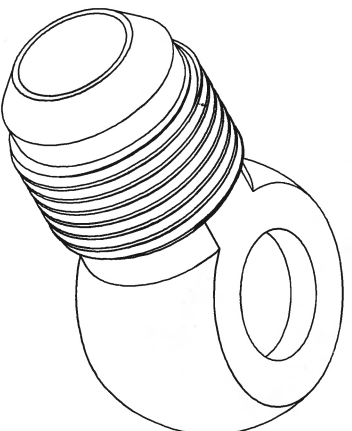
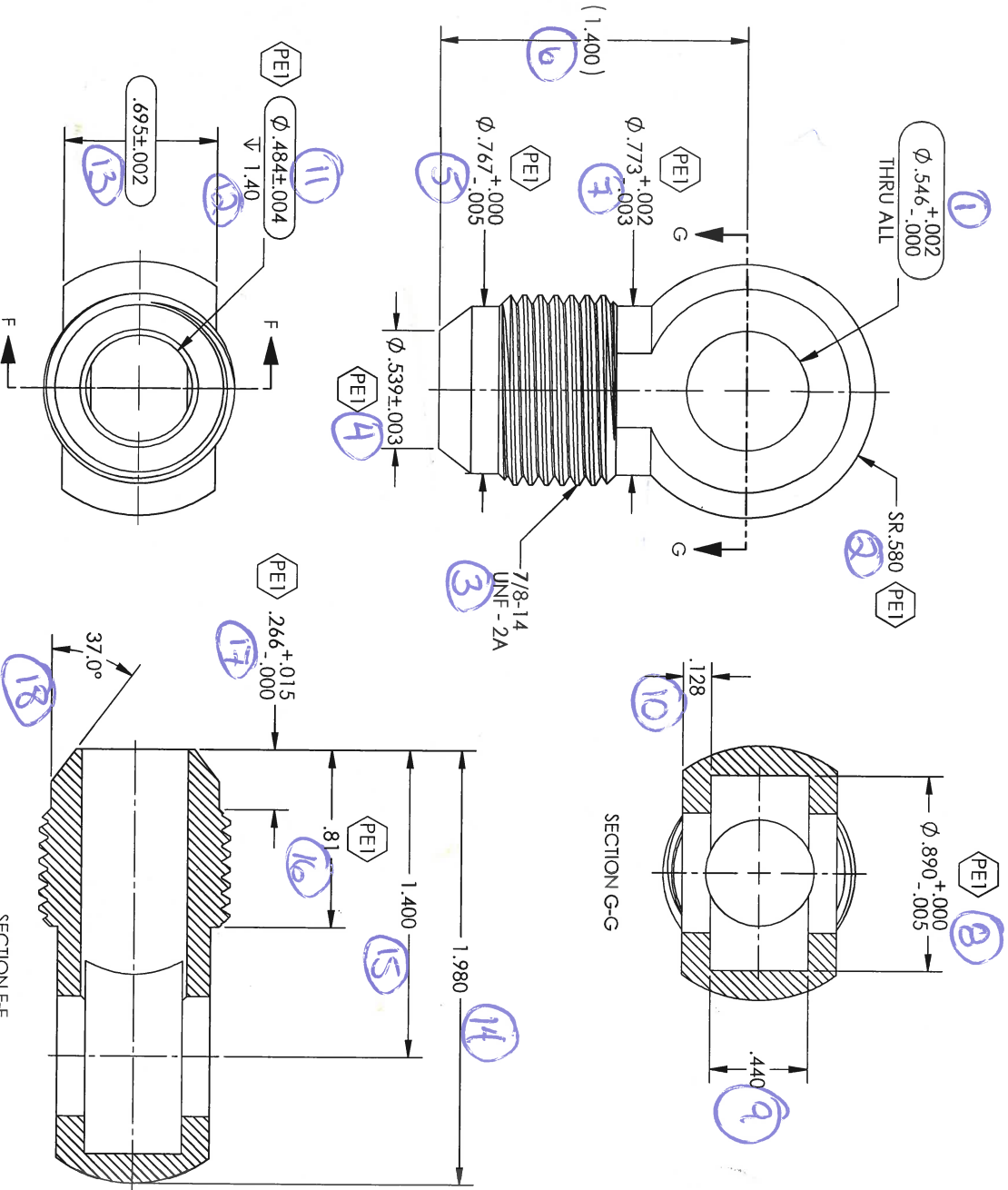
Plex 6/24/20 3:54 PM Dart.Renwick.Jennifer

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650.6213

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210873

GENERAL NOTE		DATE	
REVISION	DESCRIPTION	DATE	BY
1	ISSUED FOR PRODUCTION	04-28-2014	PEI
DRAWING APPROVAL		DATE	
DESIGNED	DATE	04-28-2014	PEI
DRAWN	DATE	04-28-2014	PEI
CHECKED	DATE	04-28-2014	PEI
APPROVED	DATE	04-28-2014	PEI
CONTRACT NO.		DATE	
UNLESS OTHERWISE SPECIFIED		DATE	
DIMENSIONS ARE IN INCHES		DATE	
3 PLACES DECIMALS 1.01		DATE	
3 PLACES DECIMALS 1.00		DATE	
SCALE NONE		DATE	
SHEET 4 OF 7		DATE	

PART 3000 ENTERPRISE CT.		DATE	
AERIAL INDUSTRIES, INC.		DATE	
AERIAL SPACE & TECHNOLOGY, INC.		DATE	
7601-24-3300		DATE	
BANO		DATE	
CAGE CODE		DATE	
B 07M16		DATE	
650.6200		DATE	
PEI		DATE	

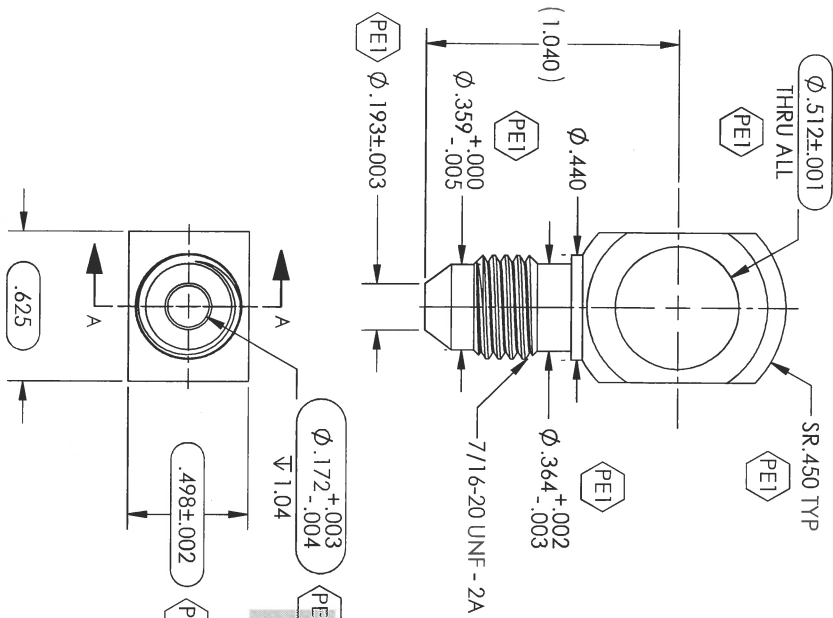
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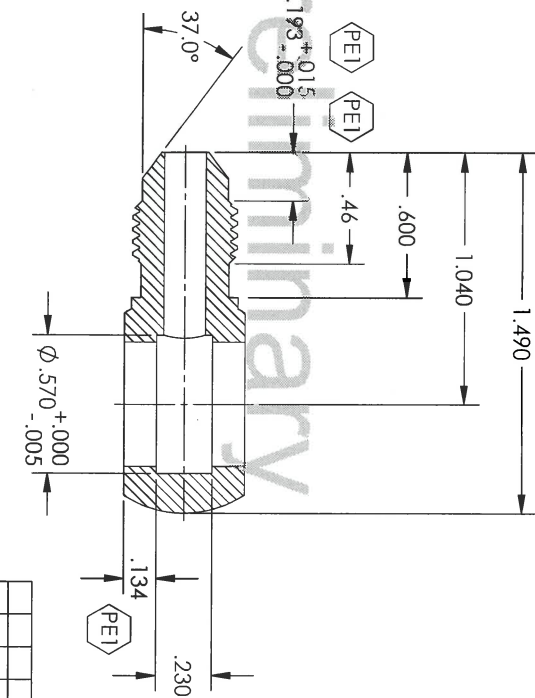
PROOF/PE REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
A-1		DIMENSION WAS $\phi .509 \pm .002$ IS $\phi .512 \pm .001$		
A-3		DIMENSION WAS $\phi .450$ TYP IS SR.450 TYP		
B-1		ADDED $\phi .930 \pm .003$ DIMENSION		
B-3		DIMENSION WAS $\phi .360$ TYP IS $\phi .364 \pm .002$ - .003		
B-4		DIMENSION WAS $\phi .170 \pm .002$ IS $\phi .172 \pm .003$ - .004		
C-1		DIMENSION WAS $\phi .460 \pm .002$ IS $\phi .464 \pm .002$		
C-3		DIMENSION WAS $\phi .500 \pm .002$ IS $\phi .504 \pm .002$		
D-1		ADDED AMS 5643 AND ASTM A564 STANDARDS		
A-4		REMOVED ELECTROPOLISH FROM NOTE 4		
A-5		DIMENSION WAS R.580 IS SR.580		
C-4		ADDED DIAMETER SYMBOL		
C-5		DIMENSION WAS $\phi .820$ IS $\phi .773 \pm .002$ - .003		
		DIMENSION WAS $\phi .720$ IS $\phi .744 \pm .002$ - .004		
		DIMENSION WAS $\phi .489 \pm .001$ IS $\phi .484 \pm .004$ - .005		
		DIMENSION WAS $\phi .280 \pm .050$ - .010 IS $\phi .266 \pm .015$ - .000		
		DIMENSION WAS $\phi .810 \pm .090$ - .010 IS .81		

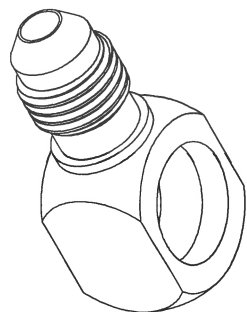
REV	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE	04-26-2014	P. BRANO
2	INCORPORATED EQUIVALENT	09-12-2014	P. BRANO
3	INCORPORATED EQUIVALENT	09-12-2015	P. BRANO
4	INCORPORATED EQUIVALENT	09-12-2015	P. BRANO
5	INCORPORATED EQUIVALENT	10-05-2016	P. BRANO
6	INCORPORATED EQUIVALENT	11-04-2016	P. BRANO



SECTION A-A



650.6210



NOTES:

1. DEBURR AND BREAK ALL SHARP EDGES.
2. MATERIAL: 17-4PH H1150 STAINLESS STEEL IAW AMS 5643 OR ASTM A564
3. IDENTIFY IAW MPP-120.
4. FINISH: IAW MPP-172 PASSIVATE IAW SECTION 6.1

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QTY	PART #	DESCRIPTION	MATL	SPEC.
7	650.6216	BANJO -4 FLARELESS	Δ	Δ
6	650.6215	DUAL BANJO -8 -10	Δ	Δ
5	650.6214	DUAL BANJO -8	Δ	Δ
4	650.6213	BANJO -10	Δ	Δ
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7	650.6216	BANJO -4 FLARELESS	Δ	Δ
			</	

DART AEROSPACE LTD

Work Order:

210873

Description: BANJO - 10

Part Number:

650.6213

Inspection Dwg: 650.6213

Rev: PE1

Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	Ø .546	+ .002 / - .000	547	✓		GP (Ref)	545 / .548
2	SR .580	± .005	579 ²	✓		Mic	JB-03
3	7/8 -14 UNF - 2A	M.O.W.	7/8-14 UNF2A	✓		GO / No-go	7/8-14-UNF2A
	MAJOR Ø	.8734 / .8631	.8673	✓		Mic	JB-09
	M.O.W. (.045)	.9001 / .8947	.8975	✓		Mic	JB-09
4	Ø .539	± .003	.5393	✓		Optical	comp.
5	Ø .767	+ .000 / - .005	.7643	✓		Mic	JB-09
6	(1.400)	± .005	1.400 ⁶	✓		optical	comp.
7	Ø .773	+ .002 / - .003	.771 ⁹	✓		Block Mic	IG-insp6
8	Ø .890	+ .000 / - .005	.886 ²	✓		inside Mic	896032
9	.440	± .005	.444	✓		Groove Mic	CNC-21
10	.128	± .005	.125 ⁵	✓		Groove Mic	CNC-21
11	Ø .484	± .004	.484	✓		GP	.480 / .488
12	1.40 DEEP	± .010	1.400 ⁵	✓		optical	comp.
13	.695	± .002	.695 ¹	✓		Mic	JB-01 JB-09
14	1.980	± .005	1.979 ⁵	✓		Vernier	JB-01
15	1.400	± .005	1.400 ⁵	✓		optical	comp
16	.81	± .010	.812 ⁶	✓		optical	comp.
17	.266	+ .015 / - .000	.272 ⁰	✓		optical	comp.
18	37.0°	± .5°	37.0°	✓		optical	comp.
19	17-4 PH H1150			✓		MILL TEST	H/T 756051
	AWS 5643 or ASTM A564						
20	PASSIVATE			✓		COFC ALTECH	

DAS
62
9-89

DAS
82
3-89

Measured by:

JB

Checked by:

SM

QC Inspector:

82

Date:

20.07.21

Date:

20/07/24

Date:

AUG 28 2020

Engineering Approval:
(If necessary)

Date:

Rev

Date

Change

Revised by

Approved

A

21-Jul-20

New Issue

MG



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046796

PO Date: 7/27/20

Due Date: 8/4/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pytm Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-07-28

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211477	650.6511	650.6500 REV.PB2	Fill Port Adapter -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X5	-	8/4/20	5 pcs	0 pcs	5 pcs	\$4.7619/pcs	\$23.81
2	210873	650.6213	650.6200 REV.PE1	Banjo -10 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed X2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52

DAS
82
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	210872	650.6210	650.6200 REV.PE1	BANJO -4 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs JUL 30 2020	3 pcs	\$4.7619/pcs	\$14.29 K
4	211168	650.6312	650.6300 REV.PG2	Screen Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs JUL 30 2020	3 pcs	\$4.7619/pcs	\$14.29 K
5	210647	650.7711	650.7700 REV.PF1	Cap Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs JUL 30 2020	3 pcs	\$4.7619/pcs	\$14.29 K



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	210875	650.6316	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52
7	211167	650.6310	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
Grand Total:												\$100.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

G. Guerin

Plex 7/28/20 1:48 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



0 2 9 8 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

029869 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
28-Jul-2020		Ian Wilson				POHB046796			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	650.6511 Rev.PB2	650.6511 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminaints. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces		PASSIVATION CH	5	5	0	0	0
2	650.6213 Rev.PE1	650.6213 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminaints. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces		PASSIVATION CH	2	2	0	0	0
3	650.6210 Rev.PE1	650.6210 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminaints. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces		PASSIVATION CH	3	3	0	0	0

RECEIVED

JUL 29 2020

DART AEROSPACE LTD.

RECEIVED

JUL 29 2020

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

029869 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax: .

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Jul-2020		Ian Wilson		POHB046796				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	650.6312 Rev.PG2	650.6312 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
5	650.7711 Rev.PF1	650.7711 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
6	650.6316 Rev.PG2	650.6316 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	2	2	0	0	0



Certificat de Conformité / Certificate of Compliance



0 2 9 8 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

029869 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Jul-2020	Ian Wilson		POHB046796					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities				
Job # / Ref #	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order			
7	650.6310 Rev.PG2	650.6310 01 - PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF: PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paint and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0

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JUL 29 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

CERTIFICATE OF TESTS
CERT SERIAL# 001200826

ABNAHMEPRUEFZEUGNIS

CERTIFICAT DE CONTROLE



CARPENTER

Carpenter Technology Corporation
101 West Barn Street, Reading, Pa. 19601
Tel: (610) 208-2000 (800) 338-4592

- THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY BE PUNISHED AS A FELONY UNDER FEDERAL STATUTES INCLUDING FEDERAL LAW TITLE 18 CHAPTER 47.
- THE VALUES AND OTHER TECHNICAL DATA REPRESENT THE RESULTS OF ANALYSES AND TESTS MADE ON SAMPLES COLLECTED FROM THE TOTAL LOT. ORIGINAL DATA RECORDS CAN BE TRACED BY REFERENCE TO THE CARPENTER ORDER NUMBER.
- MATERIAL IS MANUFACTURED FREE FROM MERCURY, RADIUM, ALPHA AND GAMMA SOURCE CONTAMINATION.
- THIS DOCUMENT SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN CONSENT OF CARPENTER TECHNOLOGY CORPORATION.

04/17/20

CUSTOMER / BESTELLER / CLIENT

AM CASTLE & CO

SUITE 220
1420 KENSINGTON RD
OAK BROOK IL 60523



SELLER / VERKAUFER / VENDEUR PAGE 1 OF 4

HVL

CUSTOMER ORDER NO. / BESTELL-NR. / N° DE COMMANDE	CARPENTER NO. / WERKS-NR. / N° DE REFERENCE INTERNE	DATE / DATUM / DATE	WEIGHT / GEWICHT / POIDS
534088	W54538	04/17/20	2664.000

HEAT NUMBER / SCHMELZE-NR. / N° DE COULÉE :

756051

UNS NUMBER S17400

PRODUCT DESCRIPTION: TYPE 17-4 SOLUTION ANNEALED COLD FINISH AGED CONDITION
H1150
PART NUMBER: 39894

SPECIFICATION: AM CASTLE AMC 3174 04 UNS S17400 REV 45 (10/17/19)
AMS 2303 REV F (REAFFIRMED) (05/ /16)
AMS 5643 MODIFIED COND H1150 REV V (01/ /18) (MOD COND H1150)
ASTM-A564/A564M COND H1150 REV. 19A
ASME SA-564/SA-564M COND H1150 2019 EDITION
DFARS 1998 EDITION
AS 6279 REV A (05/ /16)

SIZE 1.500000 IN. (38.10 MM) RD BAR

HEAT CHEMISTRY (WT%): (TEST METHOD IS SHOWN IN PARENTHESIS)

C (COM)	MN (XRF)	SI (XRF)	P (XRF)	S (COM)	CR (XRF)
0.03	0.85	0.44	0.014	0.023	15.19
NI (XRF)	MO (XRF)	CU (XRF)	N (FUS)	CB (XRF)	TA (XRF)
4.42	0.07	3.68	0.031	0.24	LT .02
CB+TA					
0.26					

NO WELD REPAIR.
MATERIAL IS MANUFACTURED FREE FROM MERCURY, RADIUM AND ALPHA SOURCE CONTAMINATION.
THIS HEAT MELTED BY THE ELECTRIC ARC/AOD PROCESSES
CARPENTER TECHNOLOGY HAS COMPLIED WITH ALL PRODUCER REQUIREMENTS OF AS 6279
COUNTRY OF ORIGIN: USA

MILL HEAT TREATMENT:
TYPE SOL ANL AGE
TEMP 1900F (1038C) 1150F (621C)
TIME (CONT FCE) 65.00 MINUTES 240.00 MINUTES
QUENCH 1AFAN COOL AIR

DISCS MACROETCHED AND APPROVED

HARDNESS AS SHIPPED 336HBW (36HRC)

CHARPY V-NOTCH IMPACT, TESTED AT 70 F LONGITUDINAL
FT-LBS (JOULES) 96.0 (130)
LAT. EXP. (INCHES (MM)) .0600 (1.524)
SHEAR FRACTURE (%) 70.0
AVERAGE: 96.0 FT/LB
SPECIMEN SIZE: 10MM X 10.0MM

CONTINUED ON NEXT PAGE

This certification is made to the customer printed on this form. Carpenter neither makes, nor assumes responsibility for, any representation or certification to other parties.
Die vorliegende Zertifizierung ist nur für den in der Form genannten Kunden gültig. Carpenter übernimmt weder über Dritten hinweg die Haftung für die angegebenen Daten oder Zertifizierungen.
Ce certificat est uniquement valable pour le client dont le nom est imprimé sur ce formulaire. Carpenter n'assume pas de responsabilité pour une certification vis-à-vis d'une tierce personne.



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

RECEIVED

JUN 2 6 2020

Page 1 of 1

DART AEROSPACE LTD Shipment No:4181535

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN	Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped 25-JUN-20	Inco Terms FCA HAWKESBURY ON CAN	Freight Terms Prepaid & Add	Carrier LOCAL FLEET	BOL No 4181535-4

Shipment Details

Final Destination Branch - TOR

Order No 5802329	Line No 1	Item No 39894	Description 1.5000.RD.17CR.4NI.STAINLESS.CF.H1150.132.0000-156.0000 SPECIFICATIONS: AMS 5643
Purchase Order No POHB046572	Part Number	Ordered Qty 12.00 FT	Invoice Qty 12.5000 FT
Details ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS			

Delivery No. 123305249	Mill CARPENTER TECHNOLOGY	Heat Number 	Mech Id	PCS 1	Width (IN)	Length (IN) 150.0000	Shipped Qty(LBS) 75.0000
----------------------------------	--	---	----------------	-----------------	-------------------	--------------------------------	------------------------------------

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 90 days of the shipment. Material cut to the correct size and quantity cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

JUN 2 5 2020

Date:

Name:

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M17-4-H1150-R1.500

PO / BATCH NO.: POHBO46572

DATE: JUN 26 2020

5285031

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: Ø 1.500

QUANTITY RECEIVED: 12.5 FT

THICKNESS RECEIVED: Ø 1.500

QUANTITY INSPECTED: 12.5 FT

SHEET SIZE ORDERED:

QUANTITY REJECTED:

SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	☒ Y ☐ N ☐	
CORROSION	Y ☒ N ☐	
CORRECT GRAIN DIRECTION	☒ Y ☐ N ☐	
CORRECT MATERIAL PER M-DRAWING	☒ Y ☐ N ☐	AMS 5643 / ASTM A564
CORRECT THICKNESS	☒ Y ☐ N ☐	
PHOTO REQUIRED	Y ☒ N ☐	
CORRECT REF # TO LINK CERT	☒ Y ☐ N ☐	756051
CORRECT MATERIAL IDENTIFICATION	☒ Y ☐ N ☐	
CORRECT M# ON THE MATERIAL	☒ Y ☐ N ☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☐ N ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☐ N ☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u> </u>	DAS	SIGNED OFF BY: <u> </u>
DATE: <u>JUN 26 2020</u>	<u>82</u>	DATE: <u> </u>
	<u>0 80</u>	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

